



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-3700-A-03

Job Sheet 170585



Part No: RBE350A94-3700-A-03

Job Qty: 16 ea

Part Name: Top



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-A Rev 7 IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	18 Ea		2/13/18	0.00	0.00	Start Up Machining-3		
120	CNC Lathe	18 pcs		2/13/18	0.00	9.00	MORI SL2500Y		
130	QC	18 pcs		2/13/18	0.00	0.00	QC2 Machining-4		
140	QC	18 pcs		2/13/18	0.00	0.00	QC8 Machining-4		
170	Outsource	18 pcs		2/13/18	0.00	0.00	Outsource12		
180	Packaging	18 pcs		2/13/18	0.00	0.00	Packaging2		
190	QC	18 pcs		2/13/18	0.00	0.00	QC6		
200	Packaging	18 pcs		2/13/18	0.00	0.00	Packaging3-1		
210	QC21-SA	18 Ea		2/13/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per DWG. FB 781 FOLIO REV: DWG REV: 2-Deburr

Descriptions: 3-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

170 - Issue P/O to Groupe Altech; PO 039090 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

9-80 2017-01-29

FEB 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-H1.000	AISI 1144 Stressproof Steel Hex Bar 1.000"	1.9800 (.11 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.

Plex 1/17/18 11:29 AM Dart.lajeunesse.marie



Container No: S043995



Part: RBE350A94-3700-A-03

Job No: 170585

Serial No/Batch: S043995

Revision: RBE350A94-3700-A

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

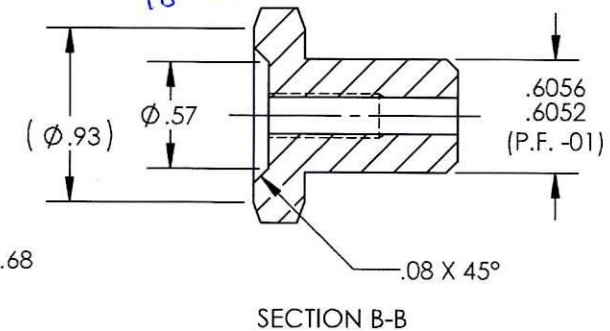
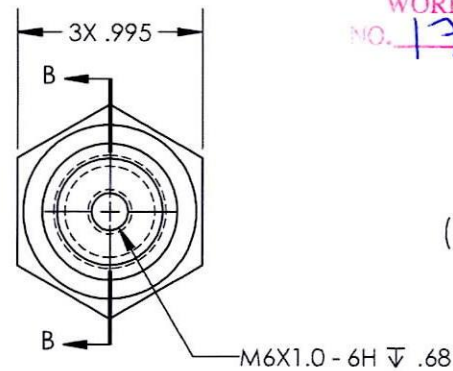
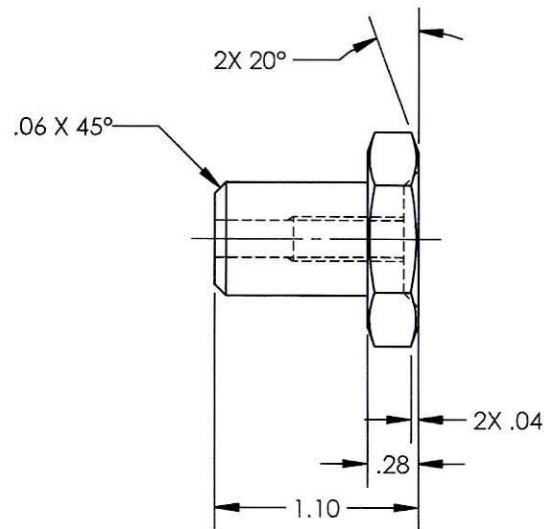
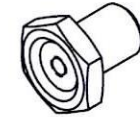
Date: 02/21/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		-03 ADDED P.F. -01 TO CAP PIN.	4/17/2013	CFS	RW
7	16-0282	-03 CH'D DIMS WAS .04 IS 2X .04, WAS P.F. -01 IS Ø.6052-.6056 (P.F. -01). ADDED FINISH QMSI-6.2.2, S.O. REV D.	1/3/2017	DPD	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 170585 405
18-01-18



(-03)

CAP

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL LONG BRACE	
DWG NO. RBE350A94-3700-A-03	REV 7
MAT'L SP	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:1	DATE 8/21/2012 SHEET 4 OF 5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																				
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																				
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																				
Large Fab ☐	Composite ☐	Supplier ☐																					
Date :	Step #:	QTY Effective :				MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition				Completed By																	
						Lead hand / Supervisor Approval Verification																	
						QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																	



Dart Aerospace Ltd.
1270 Aberdeen St
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Tel (613) 632-5200

BLANKET PURCHASE ORDER PO039090

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039090

PO Date: 2/22/18

Due Date: 3/1/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

E-MAILED
MAR 08 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Blanket Order: -

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		RBE350A94-3700-C-01	Tube -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	-		0 pcs	0 pcs	0 pcs	\$1.29/pcs	
Line Item Note parts made from T-A513 Seamless Alloy Steel Round Tubing										
	170588			Firmed	3/1/18	18 pcs	0 pcs	18 pcs	\$1.29/pcs	\$23.22
Sub Total:						18	0	18		\$23.22
2		RBE350A94-3700-A-03	Top -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	-		0 pcs	0 pcs	0 pcs	\$0.89/pcs	
Line Item Note parts made from AISI 1144 Stressproof Steel Hex Bar										
	170585			Firmed	3/1/18	24 pcs	0 pcs	24 pcs	\$0.89/pcs	\$21.36
Sub Total:						24	0	24		\$21.36
3		RBE350A94-3700-C-09	Knurled Nut -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of	-		0 pcs	0 pcs	0 pcs	\$0.95/pcs	

DAS
38
9-89



Certificat de Conformité / Certificate of Compliance

(007034-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

007034 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
07-Mar-2018		Aman			PO039090			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A94-3700-C-01 Rev.	RBE350A94-3700-C-01 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	18	18	0	0	0
2	RBE350A94-3700-A-03 Rev.	RBE350A94-3700-A-03 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	24	24	0	0	0
3	RBE350A94-3700-C-09 Rev.	RBE350A94-3700-C-09 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	10	10	0	0	0
4	RBE350A94-3700-C-03 Rev.	RBE350A94-3700-C-03 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	9	9	0	0	0
5	RBST2120-9 Rev.	RBST2120-9 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
6	RBST1007-9 Rev.	RBST1007-9 BLACK OXIDE FINISH, MIL-C-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
7	RBE350A93-3303-02-5 Rev.	RBE350A93-3303-02-5 01 -BLACK OXIDE ON SST MIL-DTL-13924D BLACK OXIDE FINISH, MIL-C-23942C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
8	RBE350A93-3303-02-7 Rev.	RBE350A93-3303-02-7 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	20	20	0	0	0
10	RBT18560-5 Rev.	RBT18560-5 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
11	RBT18582 Rev.	RBT18582 ZINC PLATE, ASTM B633 TYPE 1 SC2	ZINC CH	6	6	0	0	0
13	RBE350A94-3700-C-09 Rev.	RBE350A94-3700-C-09 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	18	18	0	0	0



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Bon de Livraison / Packing Slip

007034 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax:.

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
07-Mar-2018		Aman		PO039090				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Quantités / Quantities Comm. Exp/ /Ordered Shipped		Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.